

Date: Friday, 26/01/2007 10:12:42 AM
 User: Linda Lacelle

(4)
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 30469	Part Number	: D25777
Estimate Number	: 10601	Drawing Number	: D2577 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 26/01/2007 S.O. No. : N/A	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 15/02/2007 Qty: 15 Um: Each
Previous Run	: 30469		
Written By	:		
Checked & Approved By	:		
Comment	: Est: F 02.09.24 Re-format KJ Est Rev:G Now On Waterjet 07-01-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		Comment: Qty.: 1.0143 sf(s)/Unit Total : 15.2145 sf(s) 1010/1025/A21/6aA SHEET Batch: ml070423
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2577 Dwg Rev: E ml 07 04 23 Prog Rev: E
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 07 04 23
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK 2004.24 (15) counted
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary ml 07 04 09 (B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Appr QC Ins

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 26/01/2007 10:12:43 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30469

Part Number: D25777

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Identify as D2577-7

3-Form joggle as per Dwg D2577 using DT8157.

SB 07/05/09 15

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/10 15

8.0 POWDER COATING POWDER COATING



15X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f 07/05/11

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



15

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/11 15

10.0 PACKAGING 1 PACKAGING RESOURCE #1



15X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-16

m-f 07/05/11

11.0 QC21 FINAL INSPECTION/W/O RELEASE



15

Comment: FINAL INSPECTION/W/O RELEASE

07/05/14

Job Completion



07/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 11:08:22 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 30469		Part Number	: D25777	
Estimate Number	: 10601		Drawing Number	: D2577 REV E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 1/25/2007	S.O. No. :	Drawing Revision	: E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : PURCHASED PARTS	Due Date	:	
Previous Run	:		Qty:	Um:	
Written By	:				
Checked & Approved By	:				
Comment	: Est: F 02.09.24 Re-format KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation	Description :
1.0	PG	PURCHASING Comment: PURCHASING Issue P/O: _____ Email or Ship DXF file to vendor Laser Cut per Dwg D2577 flat pattern D2577-7 Material release note required
2.0	D2577F	Wearplate Comment: Qty.: 1.0000 U(s)/Unit Total : 15.0000 U(s) Wearplate
3.0	PACKAGING 1	PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material release note is attached
4.0	QC6	DIMENSIONAL CHECK Comment: DIMENSIONAL CHECK Inspect dimensions per template D2577-7T1
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 11:08:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30469

Part Number: D25777

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

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8.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

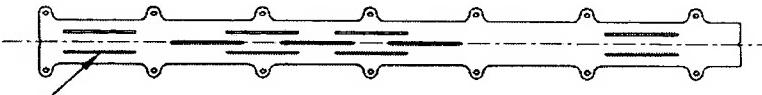
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

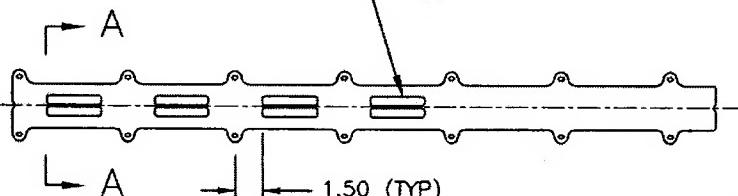


D2577-1 & D2577-3 WEARSHOE

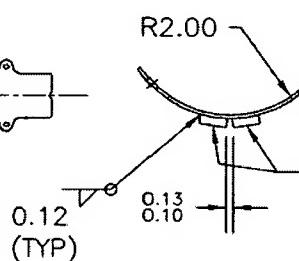
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO³⁰⁰
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 30462
D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5



D2941-300 (REF)
REMOVE POWDER
COAT FROM THESE
SURFACES

D2577-21 & D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00-04-26 11:47

DART

DART
AEROSPACE

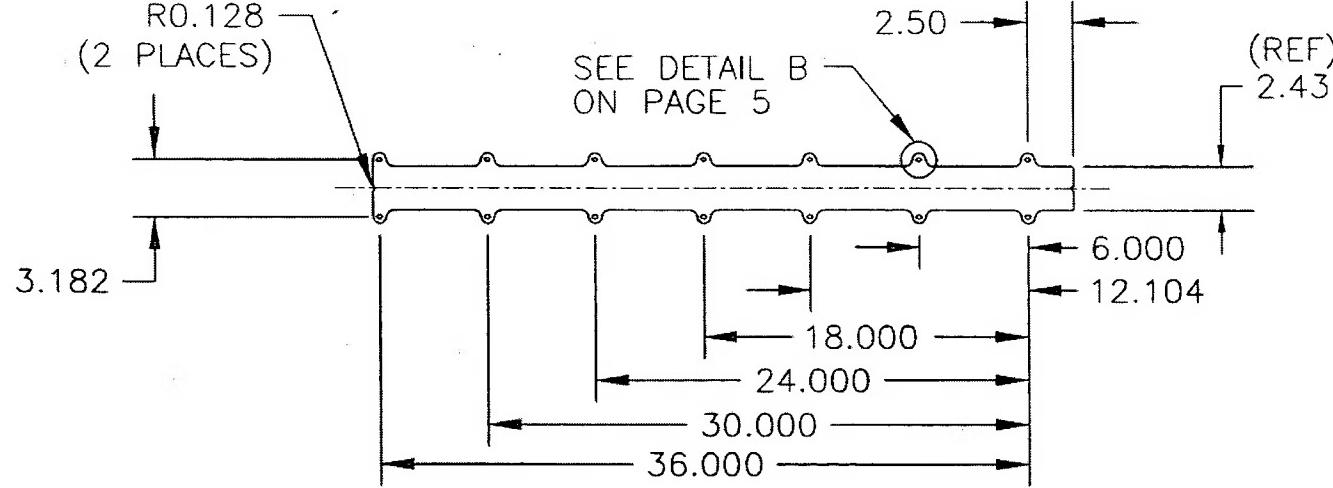
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. E
SHEET 1 OF 5
SCALE 1:10

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO. D2577
DATE	TITLE	SCALE
A	96.09.16	NEW ISSUE
B	96.12.04	ADD HARDCOAT WELDS
C	97.05.30	CHANGE HOLES TO OBROUNDS
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176

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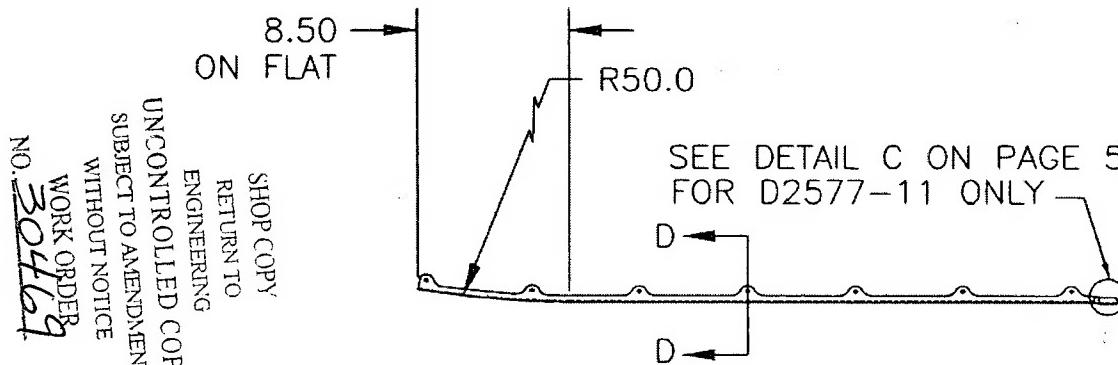


D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 30469



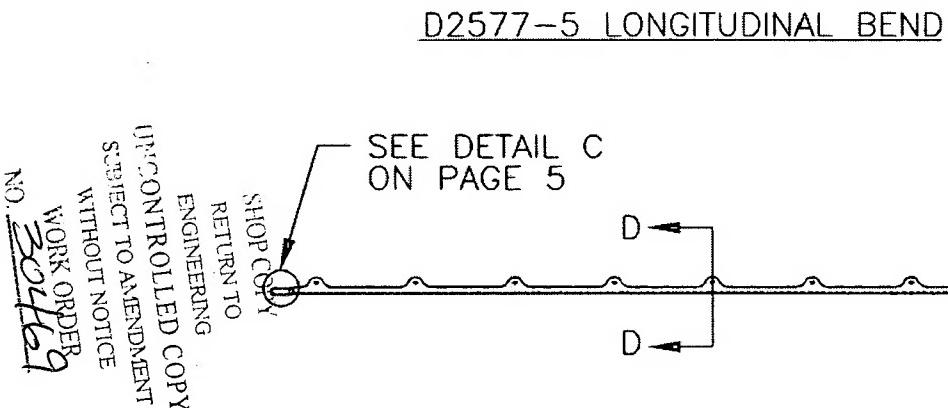
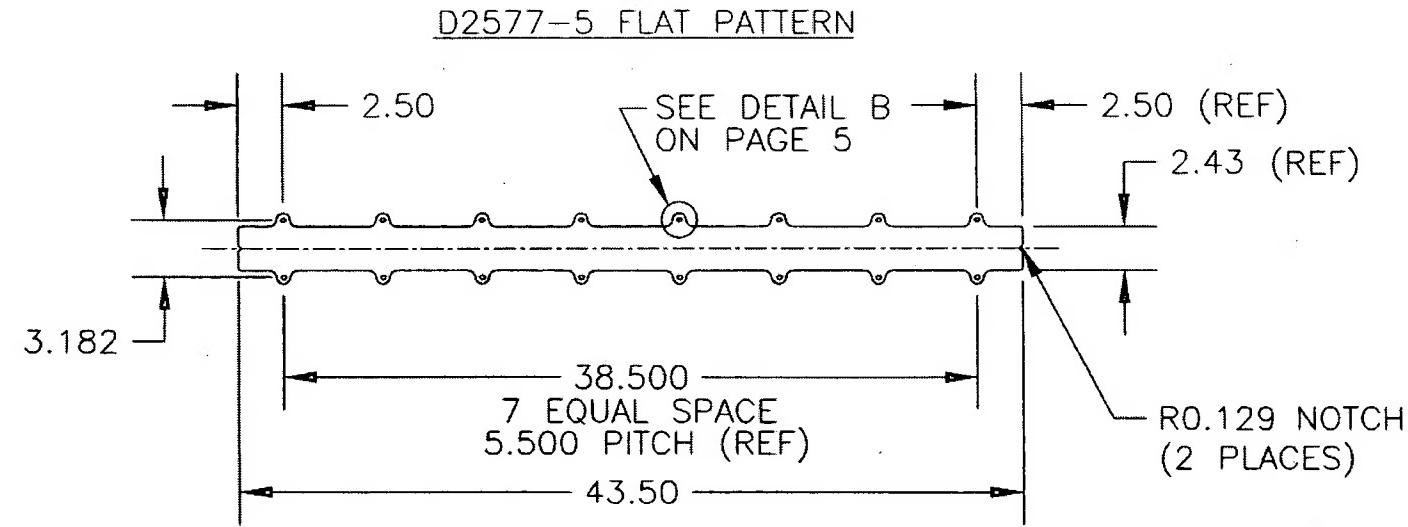
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2577
DATE		TITLE WEARSHOE
00.09.22		SCALE 1:10

RELEASED
00.09.26
H

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NO. 30469



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

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BEING
MADE

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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		REV. E
00.09.22		DRAWING NO. D2577
		SHEET 3 OF 5
		SCALE 1:10
		TITLE WEARSHOE

RELEASED

00.09.22

DART

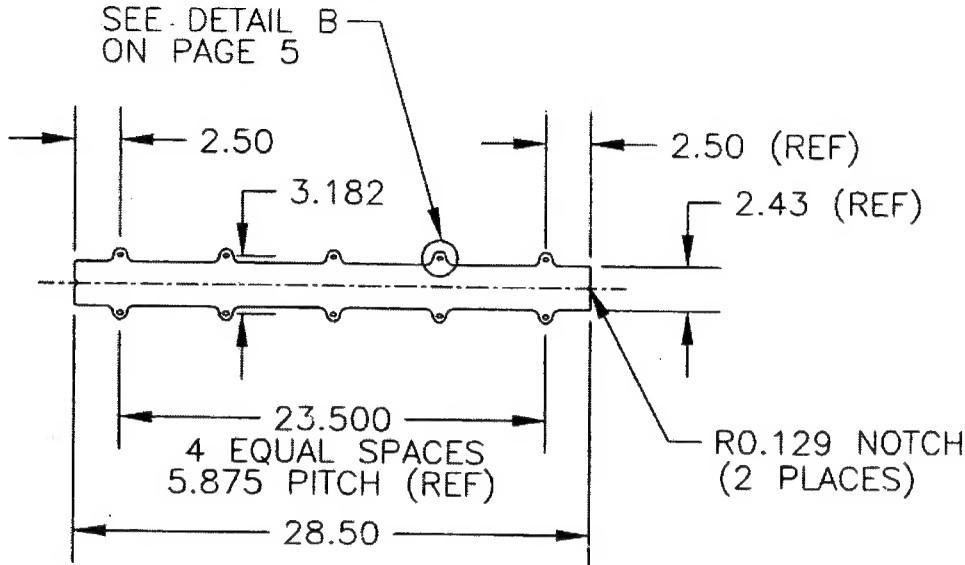


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		DATE 00.09.22
		TITLE WEARSHOE

RELEASED
00.09.26

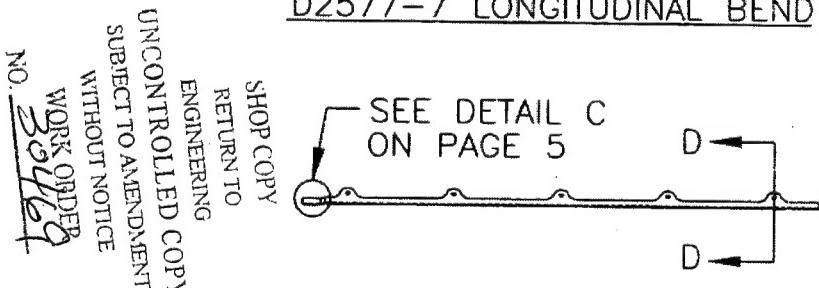
D2577-7 FLAT PATTERN

SEE DETAIL B
ON PAGE 5



D2577-7 LONGITUDINAL BEND

SEE DETAIL C
ON PAGE 5



D2577-7 WEARSHOE

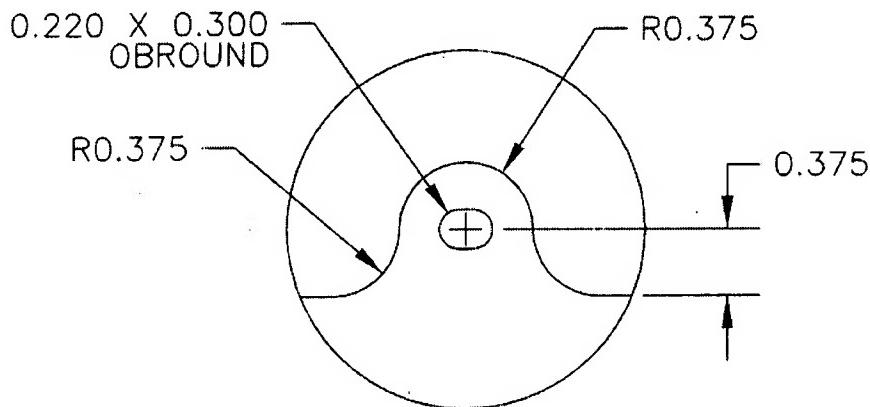
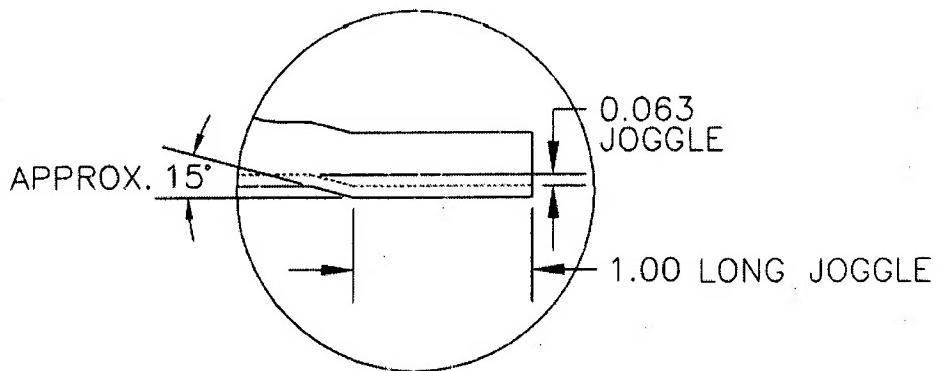
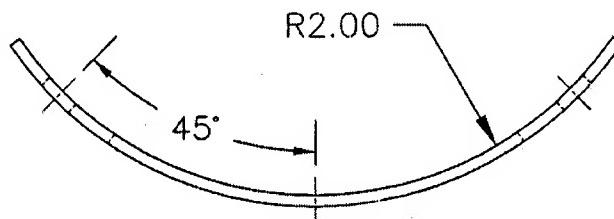
BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)**RELEASED**
(00.09.20)DETAIL C (SCALE 1:1)SECTION D-D (SCALE 1:1)

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DART AEROSPACE LTD

Work Order: 30469

Description: Wear plate

Part Number: D2571-7

Inspection Dwg: D2571 Rev: E

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 28.50	+/-0.030	28.50	✓		measuring tape	
B 23.500	+/-0.010	23.500	✓		measuring tape	
C 2.43	+/-0.030	2.431	✓		vern	
D 3.182	+/-0.010	3.188	✓		vern	
E 2.50	+/-0.030	2.506	✓		height gauge	
F 2.50	+/-0.030	2.508	✓		height gauge	
G 5.875	+/-0.010	5.880	✓		vern	
H 0.220x0.300	+/-0.010	0.220x0.300	✓		vern	
I						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	M
Date:	07/04/24

Audited by:	J
Date:	07/04/24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	